

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000378**Date Inspected:** 23-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2000**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Hou jing yao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Mock-Up 77.00**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup and welding of the Caltrans Mock-up #77.00, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Caltrans QA Inspector observed submerged arc welding (SAW) in progress at skin plate C, piecemark mp13 to MA4, inside side. The in process subassembly fabrication, appears to be at step 6.1 in regards to the mock-up fabrication procedure flow plan. The weld joint is identified as a double vee butt joint with a partial joint penetration weld. The welder operator is identified as Ms. Shen Mei. The approved welder is observed welding the partial joint penetration (PJP) weld cover pass, in the flat position. The welder is using welding procedure specification (WPS), WPS-B-T-2321-B-P3-S, Revision 0. Caltrans QA Inspector measured the operating welding parameters at approximately 690 amps, 34.0 volts, 612 millimeters per minute (mm/min) travel speed. Preheat and interpass temperatures were verified during welding activities. Preheat temperature prior to the start of welding, measured more than 110 Celsius (230 degree Fahrenheit) but less than 232 Celsius (450 degrees Fahrenheit) during maximum interpass temperature verification. Following digital picture illustrates welding in progress and, completed cover pass weld.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

ZPMC QC inspector, Mr. Lay Tao notified Caltrans QA that the welding of skin plate C splice weld is to start at 1700 hours.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
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Reviewed By:	Cuellar, Robert
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QA Reviewer
